

Attachment A (Clean copy of claims)

CLAIMS

26. Method for the manufacture of prosthetic moulded parts for the dental sector with the aid of galvanic metal deposition, in which galvanic deposition at least partly takes place by pulse-plating, characterized in that gold or a gold alloy is deposited and that the percentage pulse duration, based on the total deposition time, is at least 50%.

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27. Method according to claim 26, characterized in that galvanic deposition is ended in a time of less than 5 hours.

28. Method according to claim 27, characterized in that galvanic deposition is ended within 1 to 2 hours.

29. Method according to claim 26, characterized in that the percentage pulse duration is at least 70%.

30. Method according to claim 26, characterized in that square-wave or ramp-shaped current pulses are used.

31. Method according to claim 26, characterized in that the pulse current density is between 0.2 and 50 A/dm².

32. Method according to claim 26, characterized in that the duration of the current pulses or current intervals is in the millisecond range.

33. Method according to claim 32, characterized in that the duration of the current pulses is at least 1 ms.

34. Method according to claim 32, characterized in that the duration of the current intervals is at least 1 ms.

35. Method according to claim 26, characterized in that the prosthetic moulded part is deposited with a thickness of at least 100 μm , preferably between 150 and 300 μm .

36. Method according to claim 26, characterized in that galvanic deposition takes place from an aqueous bath.

37. Method according to claim 26, characterized in that galvanic deposition takes place from a gold sulphate bath.

38. Method according to claim 26, characterized in that galvanic deposition takes place from a bath, which contains the metal to be deposited in a higher concentration than conventional baths.

A2 39. Method according to claim 38, characterized in that a gold sulphite bath has a gold concentration of more than 30 g/l.

40. Prosthetic moulded part for the dental sector obtainable according to the method of claim 26.

41. Prosthetic moulded part for the dental sector manufactured according to the method according to claim 26.

42. Prosthetic moulded part according to claim 40, characterized in that it is veneered with ceramic or plastic.

43. Electrolytic cell for the manufacturer of prosthetic moulded parts for the dental sector with the aid of galvanic metal deposition by pulse current or pulse-plating, for performing the method according to claim 26, comprising an outer anode constructed in such a way that it at least partly surrounds a cathode to be coated with metal and which can be place in the electrolytic cell, along a circumferential line enclosing the cathode.

44. Electrolytic cell according to claim 43, characterized in that the outer anode has several anode parts along the circumferential line.

45. Electrolytic cell according to claim 43, characterized in that the outer anode is cylinder envelope-shaped.

46. Electrolytic cell according to one of the claim 43, comprising a further inner anode, which is located within the circumferential line defined by the outer anode.

47. Electrolytic cell according to claim 43, characterized in that the inner anode is an anode rod.

48. Electrolytic cell according to claim 43, characterized in that between the outer and/or inner anode and the at least one cathode are provided shielding elements.

49. Electrolytic cell according to claim 48, characterized in that the shielding elements are made from plastic.

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